

Work Order ID 69007

Wednesday, April 27, 2011 9:01:19 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4396-1

Accept



Setup Start



Revision ID: PRELIM

Item Name: Mount

Stop



Start Date: 4/27/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/28/2011 Req'd Qty: 10.00



Customer:



Reference:

Approvals:

Process Plan:

[Signature]

Date: 4-27-27 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4396

PA1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4396-1f

Dwg Rev: PA1

Prog Rev: PA1

2-Deburr if necessary

B11-4-27



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-4-27

120

0.00 - inspection to PA1



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Don't only
8/10/11



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 4/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10	BL	11427	
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				11/4/27	SL	10	
150 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00				11/4/27	SL	10	Sent to EAGLE

W/O:		WORK ORDER CHANGES					
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Accept



Setup Start



Revision ID: PRELIM

Stop



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Start Date: 4/27/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/28/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF
11-04-27

POSITIVE RECALL

EFFECTIVE 11-04-27 AUTH *CR*

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, April 27, 2011 9:01:35 AM

Page 1

Work Order ID: 69007

Parent Item: D4396-1

Parent Item Name: Mount



Start Date: 4/27/2011

Required Date: 4/28/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 11.04.27 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	91.5000	0.64	6.736842			
2024-T3 .040 sheet													



1811-4-27

Location

Loc Qty

Loc Code

MAT022

91.5

112291

0.5

112331

27

113162

64

112331



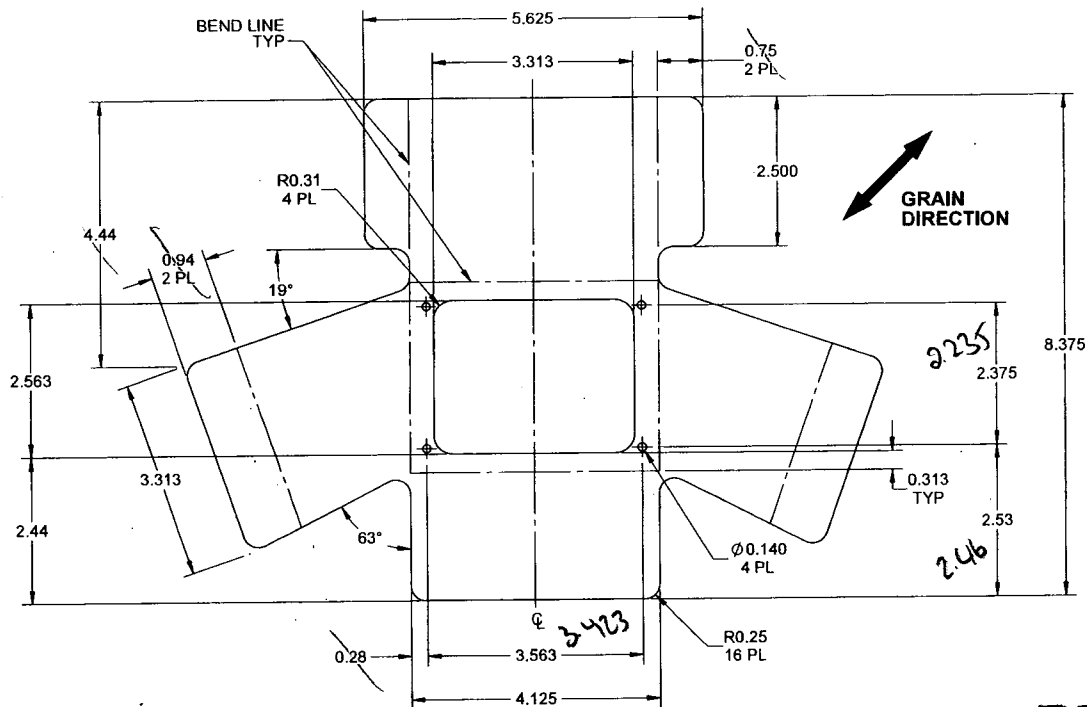
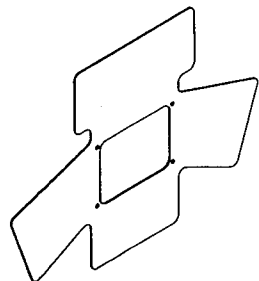
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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69007

11104-27

**PRELIMINARY
ISSUE**

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.20 lbs

D4396-1F MOUNT FLAT PATTERN

PA1	NEW ISSUE	RF	11.04.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<u>RF</u>	DRAWING NO.	REV. PA1
MFG. APPR.		D4396	SHEET 1 OF 2
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	MOUNT	NTS
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

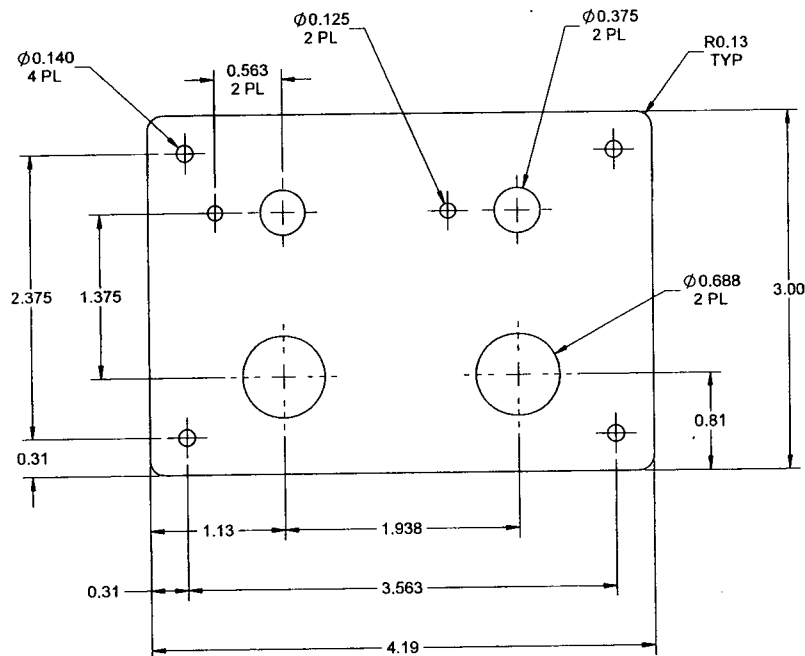
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



D4396-3 FACE PLATE

**PRELIMINARY
ISSUE**

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.040 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
REF DART SPEC M2024T3S.040
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4396	REV. PA1 SHEET 2 OF 2
MFG. APPR.		TITLE MOUNT	SCALE NTS
APPROVED	N/A	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DE APPR.	N/A		
DATE	11.04.26		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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